

Work Order ID 65154

Thursday, January 06, 2011 3:32:11 PM

Page 1

Item ID: D3209-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 1/6/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3209

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

SL 11/03/22

40

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1

□

Deburr and Tumble

OK 11/03/31

4

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 11/03/31

4

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Page 3

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 1/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

4 0 22 104106

161



Small Fab

Small Fab

Memo

press fit bushing as per dwg

0.00

0.00

= 7 m-l 11/04/13



170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

m-l 11 04 13 (4)

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Page 4

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Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 1/6/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: *Small*

0.00



Packaging

Memo

0.00

Packaging

11/4/15

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/4/18**MR**11-04-15*

Picklist Print

Thursday, January 06, 2011 3:32:16 PM

Page 1

Work Order ID: 65154



Parent Item: D3209-041



Parent Item Name: Bracket Assembly

Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 04.06.09 New issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3209-3 Bushing		Manufactured	No			100	Each	43.0000	1	4			
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Location	Loc Qty	Loc Code
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ST045	43	
35633 ✓	2	
40930 ✓	41	

M6061T6B1.500X01.25 0		Purchased	No			170	f	20.0204	0.175	0.736842			
--------------------------	--	-----------	----	--	--	-----	---	---------	-------	----------	--	--	--



6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code
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MAT10	20.02035	
107461	1.73315	
110936	18.2872	

M-1 11/04/13

2X
2X

22 11/03/22

74

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

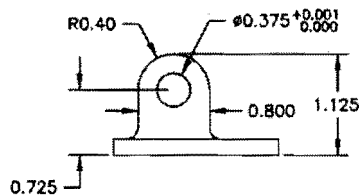
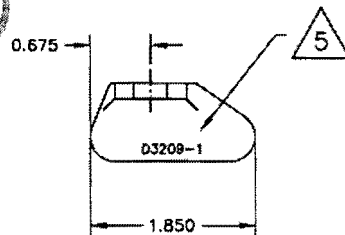
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

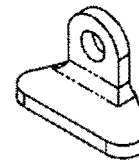
DART

DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED TF	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	

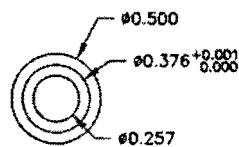
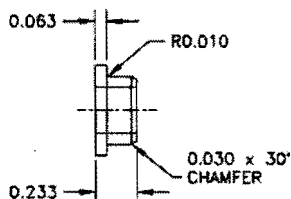
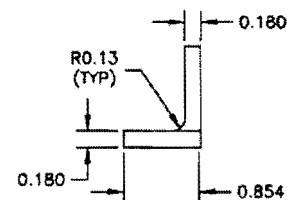
RELEASED
04.04.05



2

D3209-1 BRACKET

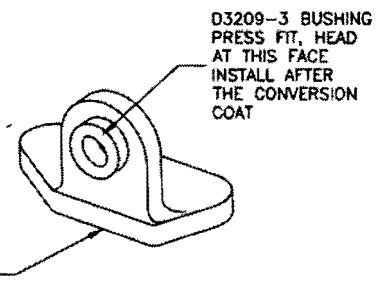
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45154
BP 11-01-7



3

**D3209-3 BUSHING
SCALE 1:2**

4

D3209-041 ASSEMBLY**D3209-1 BRACKET; D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries